

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021367**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 14-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 13AE FL2-2 floor beam to longitudinal diaphragm welds, SEG3007S-015. ZPMC welder was identified as 068501. ZPMC QC was identified as Liu Hua Jie. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with ZPMC welding procedure specification, WPS-345-SMAW-3G(3F)-FCM-1.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AE "K" plate to floor beam weld, SEG3007AH-024. ZPMC welder was identified as 050242. ZPMC QC was identified as Liu Hua Jie. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with ZPMC welding procedure specification, WPS-B-T-2233-ESAB.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AE "K" plate to floor beam weld, SEG3007AH-028. ZPMC welder was identified as 067877. ZPMC QC was identified as Liu Hua Jie. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with ZPMC welding procedure specification, WPS-B-T-2233-ESAB.

Flux Cored Arc Welding (FCAW) of OBG Segment 13AE deck panel diaphragm to floor beam flange weld,

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SEG3007F-007. ZPMC welder was identified as 066283. ZPMC QC was identified as Liu Hua Jie. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with ZPMC welding procedure specification, WPS-B-T-2232-ESAB.

ZPMC personnel fitting up OBG segment 13AE vertical plate VP3002.

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ABF QC for OBG segment 14E deck panel diaphragm welds. See MT report TL-6028 generated this date for additional information. The following welds were tested:

DP3158-001-076~081, 082~089, 094~097, 102~105, 110~112

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
